

Work Order ID 71952

Thursday, July 14, 2011 10:15:00 AM



Page 1

Item ID: D3562-042

Accept



Setup Start



Revision ID:

Stop



Item Name: Step Assembly, RH

Start Date: 7/14/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 7/22/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

Date: 11-07-14

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3562

Rev E

100

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1-Cut D2622 extrusion as per Dwg D3562
2-Deburr and bevel ends for welding

[Signature] 11.07.19

4

0

110

0.00



QC6- Inspect dimensions to drawing

QC

Memo

0.00

Quality Control

[Signature] 11 07 19 (4)

120

0.00



Chemical Conversion Coat per QSI005 4.1

HandFinish

Memo

0.00

Hand Finishing

[Signature] 11.07.09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

[illegible]

Page 2

Accept

[illegible]

Setup Start

Stop

[illegible]**Cust Item ID:**[illegible]

Customer:

Reference:

Run Start

Process Plan:

Date:

Tooling:

Date:

Stop

QC:

Date:

SPC (Y/N):

Date:

**Insp.
Stamp**

0.00

[illegible]

QC

Memo

0.00

Quality Control

140

Author's address: Department of Psychology, University of California, San Diego, La Jolla, CA 92037, USA.
E-mail: jacob@ucsd.edu

Small Fab

Small Fab

0.00

Memo

0.00

Small Fab

1- Drill Rivet holes as per dwg D3562. Touch up alodine

2- Rivet legs using Magnabond as per dwg D3562.

*****Ensure to wipe off any excess magnabond*****

A/R Magnabond 6398 Batch: 11787C

150

1. **Author(s):** [Redacted]
 2. **Title:** [Redacted]
 3. **Journal:** [Redacted]
 4. **Volume:** [Redacted]
 5. **Issue:** [Redacted]
 6. **Pages:** [Redacted]
 7. **Year:** [Redacted]
 8. **DOI:** [Redacted]
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 205. **Issue:** [Redacted]
 206. **Pages:** [Redacted]
 207. **Year:** [Redacted]
 208. **DOI:** [Redacted]
 209. **URL:** [Redacted]
 210. **Abstract:**

QC

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 71952

Thursday, July 14, 2011 10:15:00 AM



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Item ID: D3562-042

Accept



Setup Start



Revision ID:

Item Name: Step Assembly, RH

Stop



Start Date: 7/14/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 7/22/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 	Large Fab	0.00				4	0		
Large Fab	Memo	0.00							
Large Fab	1-Weld end caps as per Dwg D3562& QSI 004. Inspect for foreign objects as per QSI 024. A/RAluminum Rod <u>M114703</u> 2-Grind end cap welds flush as per Dwg D3562								
170 	QC10- Inspect visual per QSI004- ground welds	0.00							
QC	Memo	0.00							
Quality Control									
180 	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control									

11.08.19

11.08.19 → 4 0

8 ulos/23

xy

8 ulos/23

xy
RM

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID 71952

Thursday, July 14, 2011 10:15:00 AM



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Item ID: D3562-042

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Setup Start



Revision ID:

Stop



Item Name: Step Assembly, RH

Start Date: 7/14/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 7/22/2011 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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190

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

4X Ø M-11/08/24

200

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

2:00
3:20
2:30
117803

4X Ø M-11/08/25

210

Wing Walk as per dwg QSI005 4.4 Batch

0.00



HandFinish

Memo

0.00

Hand Finishing

4 - BR 11-8-30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 71952

Thursday, July 14, 2011 10:15:00 AM



Page 5

Item ID: D3562-042

Accept



Setup Start



Revision ID:

Stop



Item Name: Step Assembly, RH

Start Date: 7/14/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 7/22/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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220

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

4 RH p 11/10/08/31

230

Identify as per dwg & Stock Location: *G-A*

0.00



Packaging

Memo

0.00

Packaging

*w/o 71954**ES 11/10/08/31 (4)*

240

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/10/08/31 MF

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Thursday, July 14, 2011 10:15:06 AM

Page 1

Work Order ID: 71952

Parent Item: D3562-042

Parent Item Name: Step Assembly, RH

Start Date: 7/14/2011

Required Date: 7/22/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A New Issue 06-11-09 JLM
 IPP rev B ECN 987 07.10.09 EC verified by: DD
 IPP Rev:C ECN1048 07-12-18 DD verified by: EC
 IPP Rev:D 08-07-28 add chemical conversion coat DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D2622-120C

Manufactured

No

100

Each

121.7000

1

4



Step Extrusion

Location

Loc Qty

Loc Code

HALL

112

64409

6

68293

106

WA

9.7

46910

2

66970

7.7

D2734

Manufactured

No

140

Each

67.0000

2

8



Step End Plate

Location

Loc Qty

Loc Code

WA

67

69537

4

70701

63

D3560-042

Manufactured

No

140

Each

0.0000

1

4



Arm Weldment

D3560-044

Manufactured

No

140

Each

1.0000

1

4



Arm Weldment

Location

Loc Qty

Loc Code

WA

1

69617

1

11.08.19

4

11.08.19

8

11.08.17

11.08.17

371950

371567

371567

371567

371950

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

Picklist Print

Page 2

Thursday, July 14, 2011 10:15:06 AM

Work Order ID: 71952



Parent Item: D3562-042



Parent Item Name: Step Assembly, RH

Start Date: 7/14/2011

Required Date: 7/22/2011

Start Qty: 4.00

Required Qty: 4.00

MS20600-AD4W5

Purchased

No

160

Each

495.0000

32

128



Blind Rivet

11.08.17

Location

Loc Qty

Loc Code

ST321

118384

489

114382

173

117505

200

117739

72

117885

44

WA018

6

111477

6

8

120

Thursday, July 14, 2011 10:15:06 AM

Shop Packet Print

Page 2

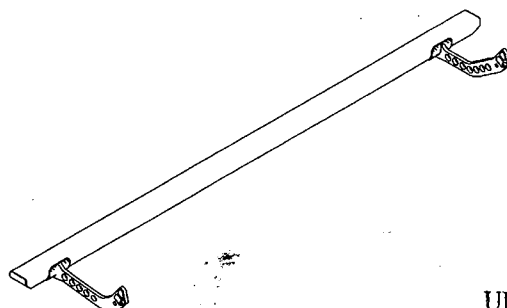
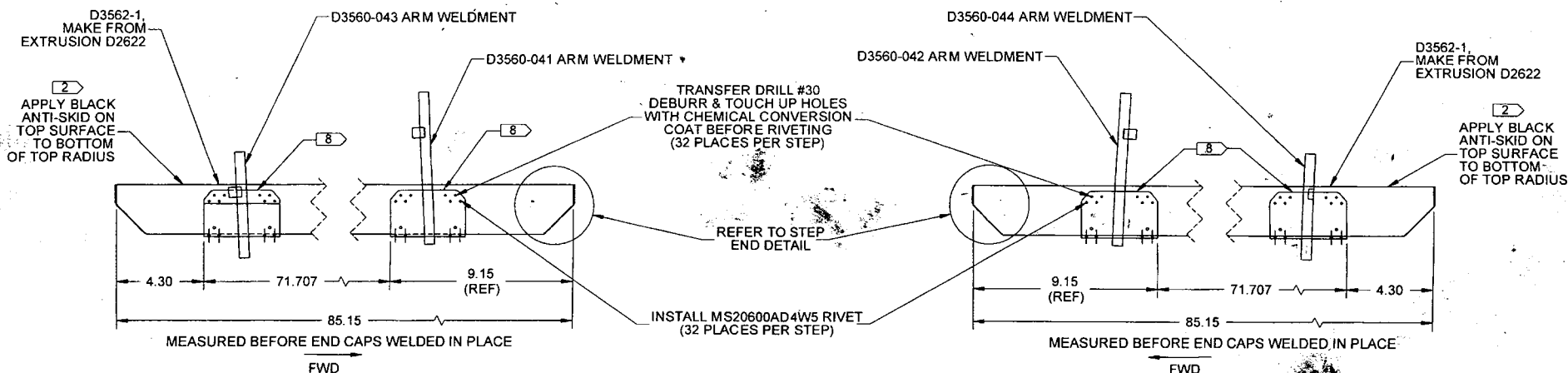
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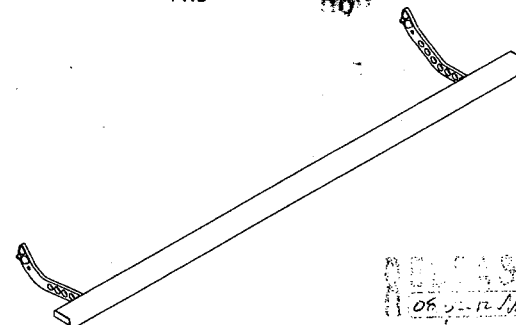
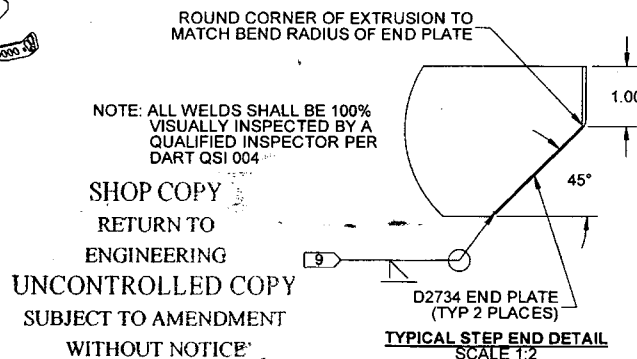
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D3562-041 LH STEP ASSEMBLY



D3562-042 RH STEP ASSEMBLY

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH:
 - i) CHEMICAL CONVERSION COAT STEP EXTRUSION PER DART QSI 005 4.1 BEFORE ASSEMBLY
 - ii) POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6) OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3
 - iii) BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 8.79 lbs
 - 8) INSTALL ARM WELDMENTS WITH A LAYER OF MAGNOBOND 6398 BETWEEN THE ARM WELDMENT AND STEP EXTRUSION. FILL ANY TOOLING HOLES WITH MAGNOBOND 6398. CLEAN OFF EXCESS BEFORE POWDER COATING.
 - 9) WELDING: PER DART QSI 004

QTY -041	QTY -042	P/N	DESCRIPTION
X		D3562-041	LH STEP ASSEMBLY
	X	D3562-042	RH STEP ASSEMBLY
1		D3560-041	ARM WELDMENT
	1	D3560-042	ARM WELDMENT
1		D3560-043	ARM WELDMENT
	1	D3560-044	ARM WELDMENT
32	32	MS20600AD4W5	RIVET
2	2	D2734	END PLATE

REV.	DESCRIPTION	BY	DATE
E	ADD QTY (2) TO D2734 END PLATE ON D3562-042	PH	08.01.11
D	REMOVE D2808 SPACER NOTE, REDRAWN IN SOLIDWORKS	DC	07.11.16
C	NOW MAGNOBOND, ADD D2808, REMOVE 4 RIVETS	CP	07.06.19
B	ARMS NOW RIVETED TO STEP	CP	07.01.15
A	NEW ISSUE	CP	06.09.26
DESIGN	GP	DATE	08.01.11
DRAWN	SE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	LE	DRAWING NO. D3562	
MFG. APPR.	MD	TITLE STEP ASSEMBLY	
APPROVED	MD	SCALE 1:5	
DE APPR.	MD	SHEET 1 OF 1	
DATE	08.01.11	COPYRIGHT © 2006 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

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